

Work Order ID 63667

Tuesday, November 09, 2010 12:52:39 PM



Page 1

Item ID: D4019-3

Accept



Setup Start



Revision ID:

Item Name: Rib

3

Start Date: 11/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *MWP*

Date: 10-11-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4019

Rev D

10.11.10

0.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY*PL 10-11-10*

100



Large Fab

Memo

0.00

1- Cut tube as per dwg D4019
2- remove identification marks and deburr

*SAD
10-11-69*

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*S. Dulko**(X-3)*

120



Packaging

Packaging

Identify as per dwg & Stock Location: *B/C*

0.00

Memo

0.00

PL 10-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63667

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Tuesday, November 09, 2010 12:52:40 PM

Item ID: D4019-3

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 11/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

0.00

 10-11-10


QC

Quality Control

Memo

 10/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 63667



Parent Item: D4019-3



Parent Item Name: Rib

Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg revC DD 10.04.20 verified by:EC IPP Rev:D as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS0.750W.06 2		Purchased	No			100	f	147.2282	1.75	11.05263			



6061-T6 SQ Tube .75 x .75 x .062W



SAD 10-11-09

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	69.55297	
114573	22.1055	
114640	47.44747	5.5263
MAT06	77.6752	
103069	38.0526	
104422	15.5263	
16441	4.07	
9671	20.0263	

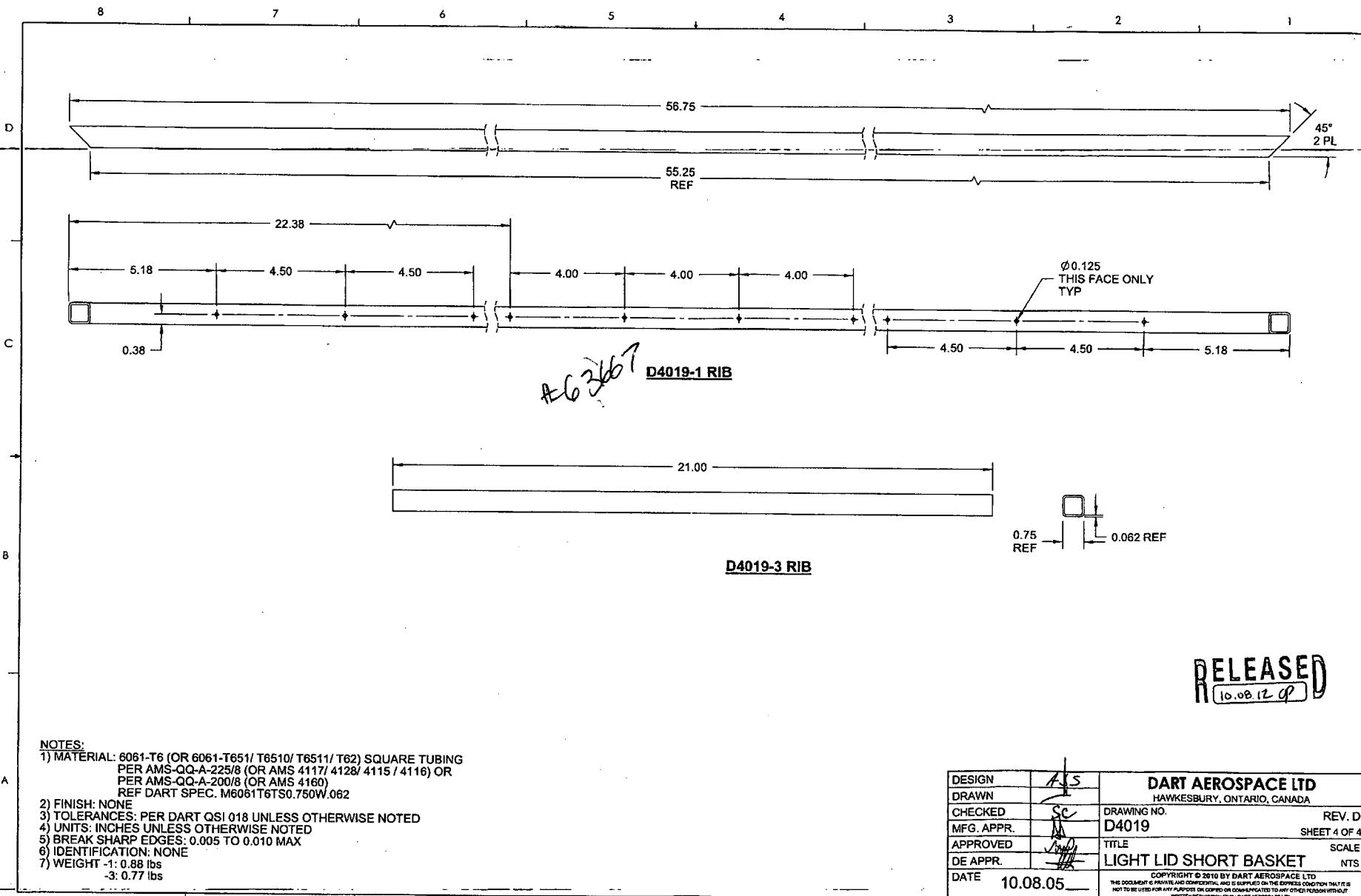
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Receiving Report

Date: 10/5/10
Supplier: The nests

Batch No: M114640

Dart P/O: 11825

Packing Slip: Yes No
Invoice: Yes No
Receipt: Cash Cr

Release Note Attached: Yes No N/A
Waybill Attached: Yes No N/A
Shipment Complete: Yes No N/A
QC6 Inspection N/A
Work Order N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

Location



100 Constitution Drive
P.O. Box 644
Exton, PA 19341-0644

METALS
O'Neal High-Performance
Metals Group

* INVOICE *

REMIT TO:

TW METALS, INC
PO. BOX 933014
ATLANTA

GA 31193-3014

RECEIVED MAY 13 2010

SALES OFFICE 585-768-5600

FED ID: 25-0883470

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKSBURY ON K6A 1K7
CANADA

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKSBURY ON K6A 1K7
ONTARIO CANADA

ITEM DESCRIPTION			DATE SHIPPED	DATE PAYM. DUE	INVOICE NUMBER
SHIP	BAX 3-5 DAY	C 1203820	05/05/10	05/05/10	80394474
			NET 30 DAYS		
1	D6061-T6 3/4 SQ X .065 WA RD CORNER ECCN:EAR99	LENGTH: 12 FT ML	120.000 FT 10 EA	3.5000 FT	420.00

1244
.. 1236

ITEM DESCRIPTION	UNIT PRICE	QUANTITY	WEIGHT	SALES TAX	TOTAL INVOICE
1/1	420.00	.00	.00	.00	420.00
ORIGINAL	IF PAID WITHIN DISCOUNT PERIOD DISCOUNT		.00	.00000	

REVERSE SIDE FOR YOUR CAREFUL REVIEW.
OF THESE PRODUCTS ARE SET FORTH ON THE
TERMS AND CONDITIONS ATTACHED TO THE SALE

DATE 11/11/10

DATE SHIPPED

THESE TERMS AND CONDITIONS OF SALE

12.5000

LENGTH

11.000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

ON K6A 1K7

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

12.5000

CONFIRMED DATE: 05/11/10 REC'D DATE: 05/11/10

SHIP TO: 12008420 MFR: 1000

FROM: CHIC PAGE 1

ORDER NO: 120084474

PACKING SLIP

PACKING SLIP

ORDER NO. 2636474 FROM: CHICAGO

PAGE 2

NUMBER: 1402620 NET WT: 24.710 REQ. DATE: 05/11/10 CONFIRMED

SHIP TO: DART AEROSPACE LTD

1270 AEROPARK ST. HAWTHORPE ON L1K 1L2

TEL: 562 1575 FAX: 562 1575

C- K6A 1K7

CHICAGO

11-5018

Customer may obtain a copy of the above document on the web site at www.msmetals.com. MSDS information is also available on the web site at www.msmetals.com. Product Statistics

can be obtained by calling 800-331-1111 or fax a copy of our current

Date: 5/05/10

This packing slip has been exported from the United States in accordance with the laws of the United States and the regulations of the U.S. Customs Service.

TERMS AND CONDITIONS APPLICABLE TO THE SALE OF THESE PRODUCTS ARE SET FORTH ON THE REVERSE SIDE FOR YOUR CAREFUL REVIEW.

KAISER

ALUMINUM

FABRICATED PRODUCTS

CERTIFIED TEST REPORT

<http://Certs.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

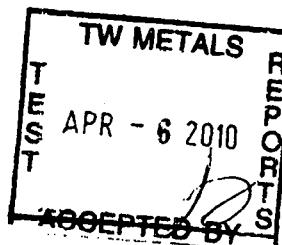
CUSTOMER PO NUMBER:		CUSTOMER PART NUMBER:		PRODUCT DESCRIPTION:			
M49225809-1		86913		Seamless Tube/Pipe			
KAISER ORDER NUMBER:	LINE ITEM:	SHIP DATE:	KAISER LOT NUMBER:	ALLOY:	TEMPER:		
205020	001	03/27/2010	F00007573	6061	T6		
WEIGHT SHIPPED:	QUANTITY:	B/L NUMBER:	DIAM/DAF/THKNS:	WIDTH:	LENGTH:		
459.000 LB	198.000 PCS	204253			12.000 FT		
SHIP TO:				SOLD TO:			
TW METALS INC 235 WEST TUBEWAY DRIVE CAROL STREAM, IL 60188 USA				TW METALS INC 760 CONSTITUTION DRIVE SUITE 204 EXTON, PA 19341 USA			

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CON%IACS	BEND
F00007573	0001	1	48.7	46.5	15.9	N/A	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
D67811	.59	.29	.24	.06	.96	.06	.06	.02	.00	.00	.00	.01	.02
D67767	.62	.33	.24	.05	.96	.09	.07	.03	.00	.00	.00	.01	.02



CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Chris Garcia, Quality System Engineer

Christopher Garcia

Plant Serial: 00006613

Kaiser Order Number: 205020

Line Item: 001

PURCHASE ORDERPurchase Order ID **PO11825**Purchase Order Date 5/04/10
PO Print Date 5/04/10

Page Number 1 of 1

Order From :TW METALS
PO BOX 933014
ALTANTA, GA 31193-3014
US

VU-TWM001

Contact NameVendor Phone 585 768 5600
Vendor Fax 585 768 5601

Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency USD
FOB**Ship To :** DART AEROSPACE LTD1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA**FAXED**
5/04/10

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
		Vendor Part Number					
1	M6061T6TS0.750W.062	6061-T6 SQ Tube .75 x .75 x .062W	5/11/10	✓ 120.00		\$3.5000	\$420.00

Yes f

Special Inst: MATERIAL: 6061-T6 OR 6061-T62
TUBING PER
WW-T-700/6 OR AMS4080 OR AMS 4082
OR
QQ-A-200/8 OR QQ-A-225/8
MATERIAL: 6061-T6 SQUARE TUBING
.750" X .750" X .065" WALL

PO Total: \$420.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY****PO Instructions:**

PLEASE SHIP: BAX GLOBAL ACCT:152700192

Change Nbr: 1

Change Date: 5/04/10

No substitution or deviation without
consent.Certificate of Conformity or Material
Certification required when applicable